

16/08/2007 3:10:52 PM

Cacelle

Process Sheet

Order Number : CU-DAR001 Dart Helicopters Services
 Estimate Number : 34042
 P.O. Number : 10973
 This Issue : N/A
 Prsht Rev. : NC
 First Issue : 16/08/2007 S.O. No. : N/A
 Previous Run : 34041 Type : LANDING GEAR

Drawing Name : 206L AFT X-TUBE

Part Number : D206667203
 Drawing Number : D206-667-243 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 05/09/2007

Qty: 1 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

2.0 D6004115 Crosstube material

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115

Crosstube

Check OD = 2.500"; ID = 1.800"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

4.0 QC1 INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

SP 07/08/17

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SP 07/08/17

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 07/08/17

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP 7-9-4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/08/17

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP 7-9-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	BENDING	BENDING MACHINE
------	---------	-----------------



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-9-4

12.0	QC15	DIMENSIONAL CHECK OF X-TUBES
------	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

20-09-05 (1)

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

85
07-09-05

JD 7-9-6

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-9-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

25/09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *on 09/09/11*

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *checked all holes on 09/09/11*

17.0 OUTSIDE SERV.10 OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: *4568*
LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order
0207/09/12 ①

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.
02/09/12 ①

19.0 QC6 DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103
07/09/12 ①

20.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Intron as per QSI 005 4.2

07-09-19
Issue P/O 4630 Heliver Debossed type
Blue?
0207/09/20 ①
07/09/24
07/09/24

21.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

22.0	D2873045	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32777

25 07-09-19

23.0	D2873043	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

32912

25 07-09-19

24.0	MS20601AD4W10	RIVET
------	---------------	-------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

25 07-09-19

25.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

25 07-09-19

26.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

34293

27.0	D28921	Support
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

32374

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-22

Clamp

104 222*1 / 105066 & 07-09-24

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT
07-09-24

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

109.25 @

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850

CP

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104547

CP

CP 07/09/250

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RD Date: 07/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:10:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34042

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	AN510A	Bolt
------	--------	------



GB



GB Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M105433

35.0	AN532A	Bolt
------	--------	------



GB



GB Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M103962

36.0	AN960JD516	Washer
------	------------	--------



GB



GB Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M104156

GB 07/09/250

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

GB 06/09/25

38.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

GB 07/09/250

39.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

DG 07/09/25

Job Completion



B34042

GB 07/09/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 #

UNDER REVIEW
06.08.10 RH
re draw detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

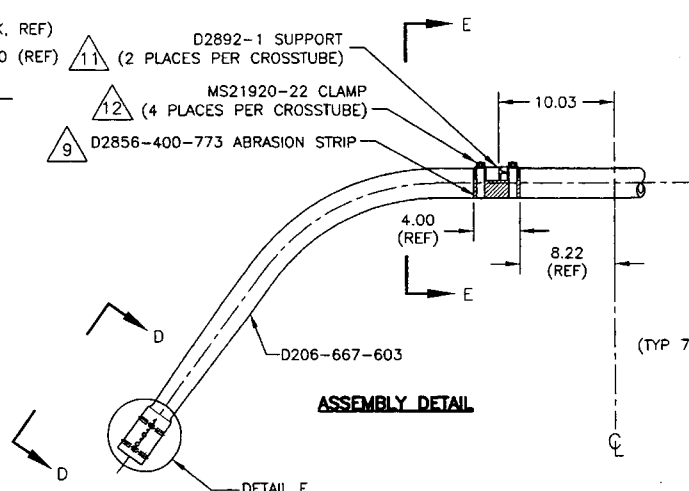
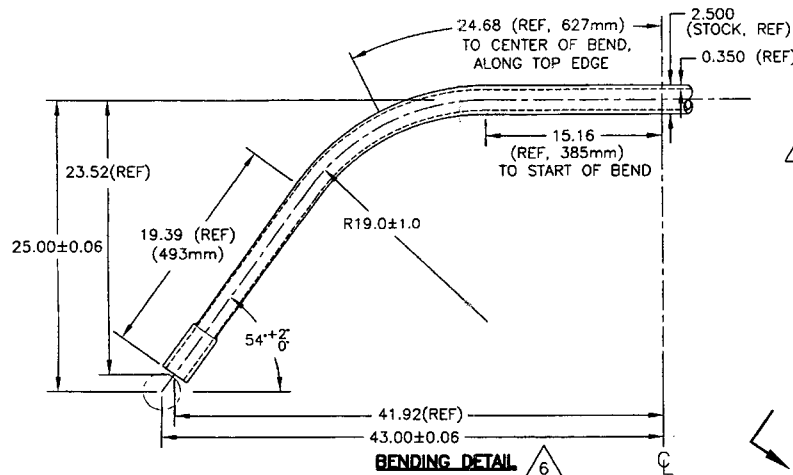
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

w/o
34042

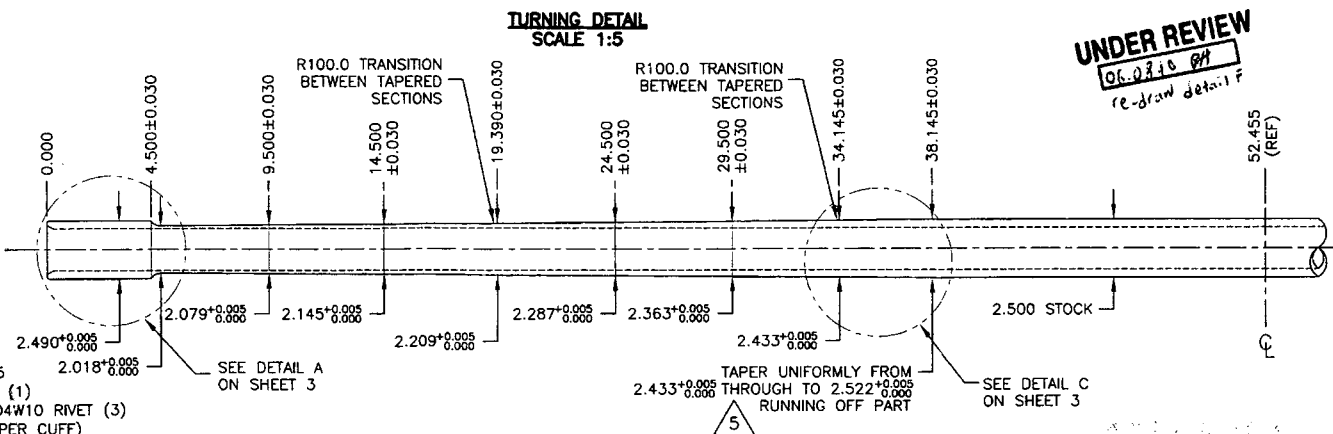
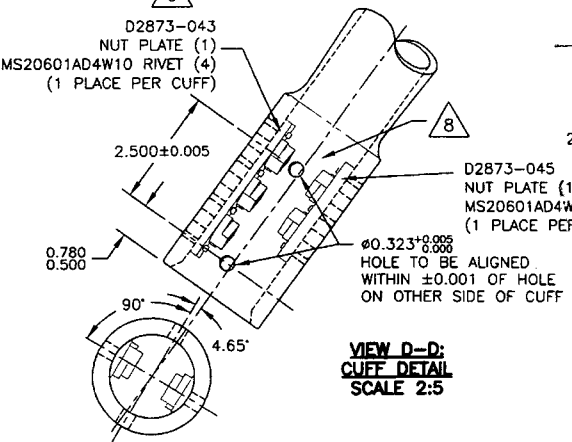
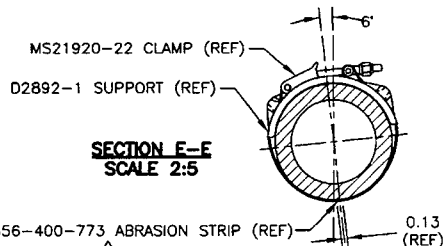
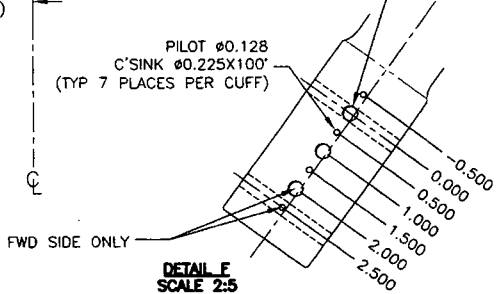
Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001 OF HOLE ON OTHER SIDE OF CUFF

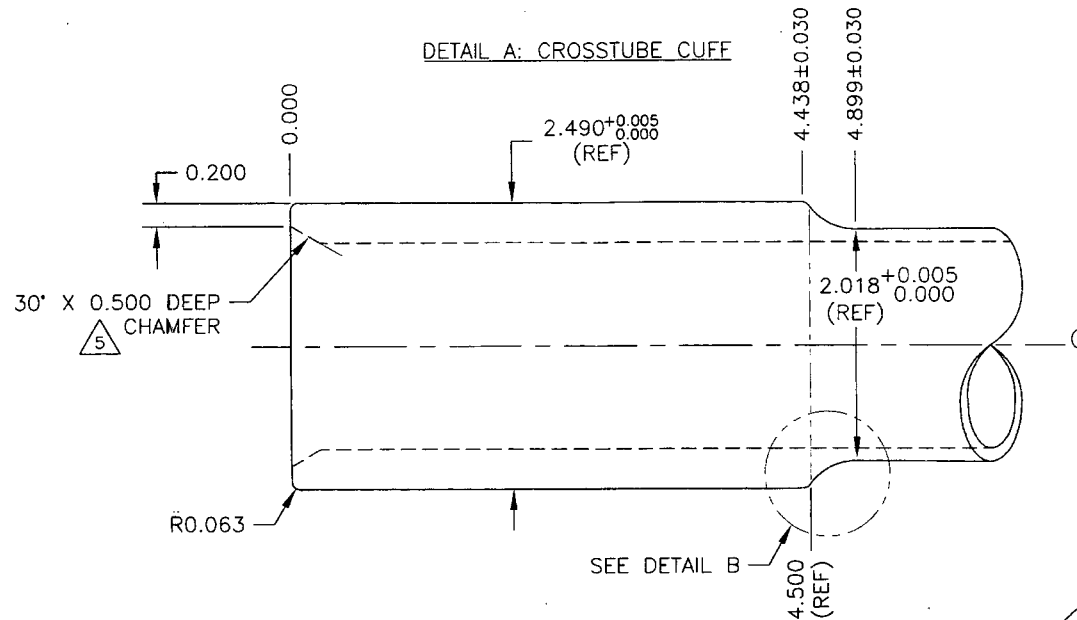
PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 1.00$
(TYP 7 PLACES PER CUFF)



UNDER REVIEW
06.07.10 PH
re-draw detail F

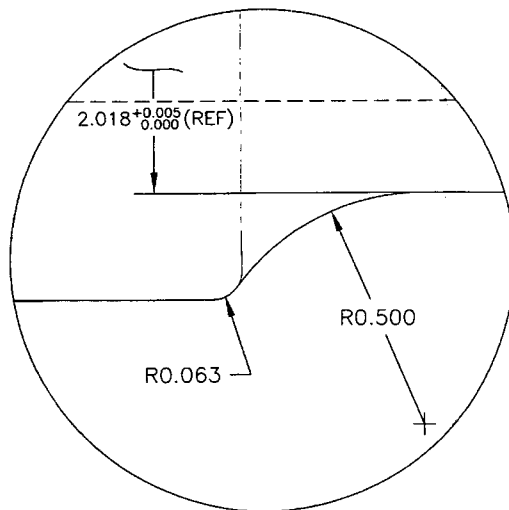
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA	REV. B
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH		
		CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
		DS	DS	D206-667-243	
		DATE		TITLE	SCALE
		05.07.26		CROSSTUBE ASS'Y (206L HIGH AFT)	1:10

DETAIL A: CROSSTUBE CUFF



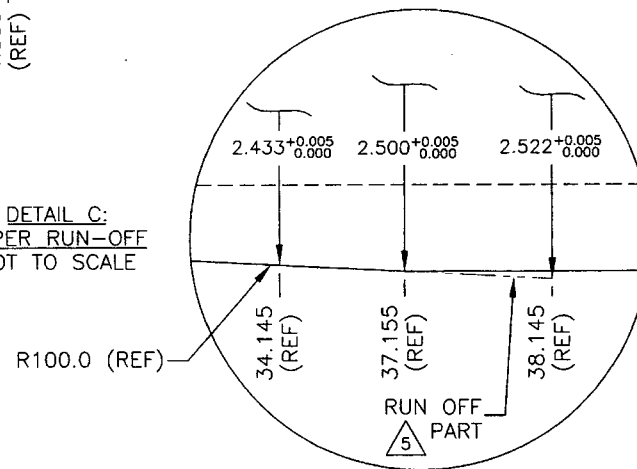
05.07.26

UNDER REVIEW
06.03.10 PH
re-draw detail F



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF NOT TO SCALE



COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1	

DART AEROSPACE LTD		Work Order: 34042
Description: Crosstube Assembly		Part Number: D206-667-243
Inspection Dwg: D206-667-243 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.492				
	2.018	+0.005/-0.000	2.020				
	2.079	+0.005/-0.000	2.081				
	2.145	+0.005/-0.000	2.147				
	2.209	+0.005/-0.000	2.210				
	2.287	+0.005/-0.000	2.289				
	2.363	+0.005/-0.000	2.365				
	2.433	+0.005/-0.000	2.437				
	0.200	+/-0.010	.200				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				
SIDE B	104.91	+/-0.020	104.91				
	2.490	+0.005/-0.000	2.493				
	2.018	+0.005/-0.000	2.020				
	2.079	+0.005/-0.000	2.081				
	2.145	+0.005/-0.000	2.147				
	2.209	+0.005/-0.000	2.211				
	2.287	+0.005/-0.000	2.289				
	2.363	+0.005/-0.000	2.365				
	2.433	+0.005/-0.000	2.438				
	0.200	+/-0.010	.200				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				

Measured by: JB	Audited by: SC	Prototype Approval:	N/A
Date: 07/05/17	Date: 07-08-29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

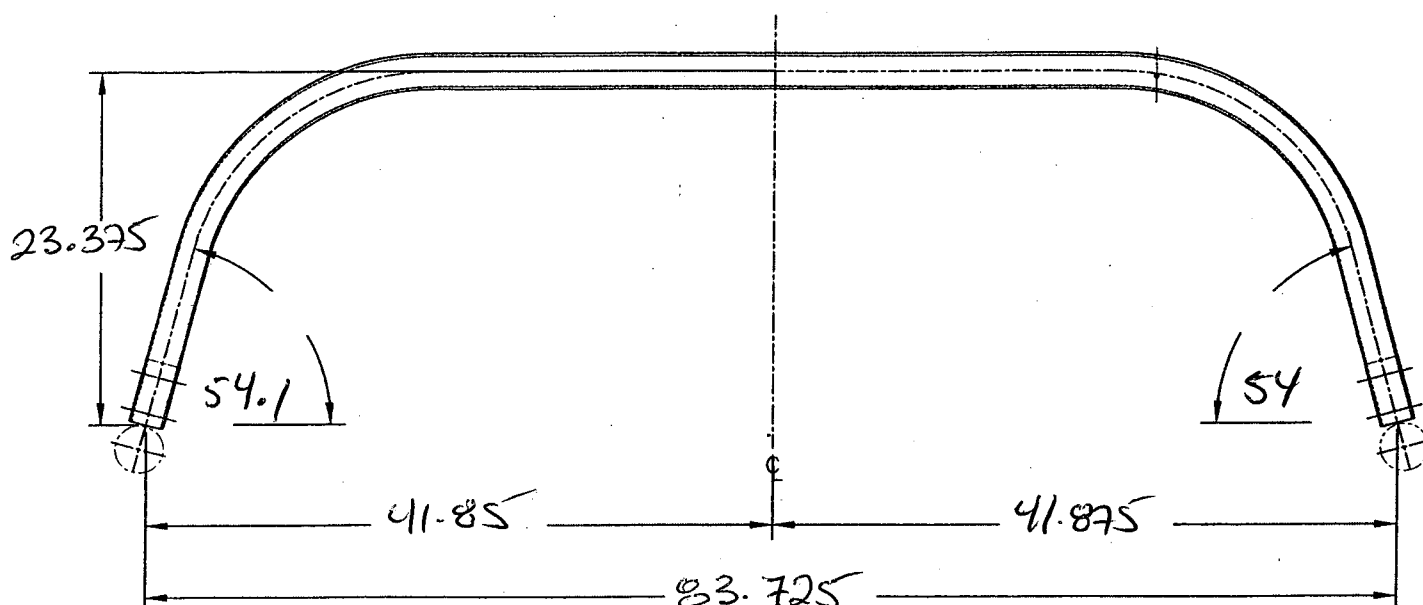
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34042
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Tube is short 0.145" from nominal. Drill cuffs at 0.600" to make the tube higher and within tolerance.

QC15 Inspection	2 070905
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**HeathAir**
INTERNATIONAL (1991) INC.681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37465

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D212-664-201 S/N's B32682, B32679 and B32683.

Qty (1) P/N D412-664-203 S/N B32230.

Qty (3) P/N D206-667-203 S/N's B34042, B34049 and B34048.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(7) cross tubes inspected. (7) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE September 18, 2007

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00004568

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR	Ⓢ	\$
MATERIALS	Ⓢ	
TRAVEL EXPENSES	Ⓢ	GST
HOTEL EXPENSES	Ⓢ	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT